

Work Order ID 135749

Tuesday, August 18, 2015 2:30:46 PM

135749

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Item ID: D4170-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bushing
 Start Date: 8/18/2015 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 8/18/2015 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: AUG 18 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4170	B

100	Hardinge CNC LATHE SMALL	0.00				10	Ø		DAS 44 9-89 15/08/20
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100

Hardinge

Hardinge CNC Lathe Small

Memo

Machine as per Folio FA989

FOLIO REV: N/A

DWG REV: B

DEBURR

110	QC2- Inspect parts off machine FAI/FAIB	0.00				10	Ø		DAS 44 9-89 15/08/20
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110

QC

Quality Control

Memo

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						10	0		JH 2015-08-20
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: <u>ST096</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging	*** STOCK IN STORES***								
			DAS 6 9-89			10	JA	AUG 20 2015	
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

20150821 SH

Picklist Print

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Parent Item: D4170-3

D4170-3

Parent Item Name: Bushing

Start Date: 8/18/2015

Required Date: 8/18/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 10-10-28 JLM VERIFIED BY:DD IPP
Rev:A 10.11.02 as per revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500		Purchased	No				f	56.3750		2.75	DAS 44 9-89	15/08/20	
M6061T6R0 500										**			
6061-T6 Round Bar .500"													

Location

Loc Qty

Loc Code

MAT012

56.375

M129845

0.775

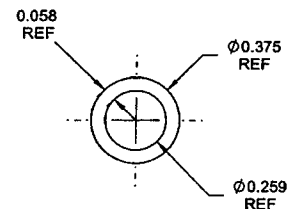
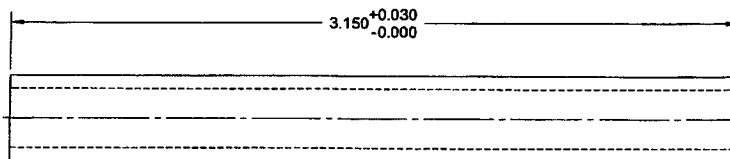
✕ M132320

7.6

M132876

48

3.921



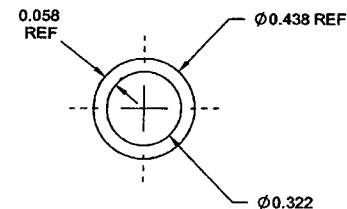
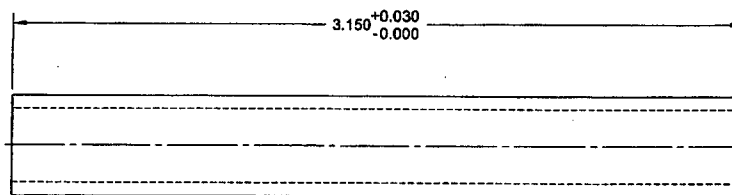
D4170-1 SPACER

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, $\phi 3/8$ OD X 0.058 WALL.
PER WW-T-700/8, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC. M6061T6T0.375W.058
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

RELEASED
2010-11-01

B	ADD -3 (SHEET 2)	CP	10.10.25
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SG	DART AEROSPACE USA, INC.	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JP	D4170	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	SPACER	NTS
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D4170-3 SPACER

NOTES:

- 1) MATERIAL: 6061-T6 ROUND BAR, $\phi 7/16$ OD
PER QQ-A-225/8, QQ-A-200/8, ASTM B211, OR ASTM B221
REF DART SPEC. M6061T6R0.438
- OR
6061-T6 OR 6061-T62 TUBING, $\phi 7/16$ OD X 0.058 WALL
PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC. M6061T6T0.438W.058
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

RELEASED
2010-11-01

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D4170	REV. B
MFG. APPR.		SHEET 2 OF 2	
APPROVED		TITLE	SCALE
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